

# Work Order ID 85046

May 31-12 3:40:39 PM

**\*85046\***

Page 1

Item ID: D4110-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Doubler, Sill

Start Date: 31/05/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/01* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4110	A
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100

0.00

**\*100\***

Waterjet

Memo

0.00

FLOW CNC Waterjet

*304 . 0.5*

1-Cut as per Dwg

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

*12-6-18*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*12-6-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 85046****\*85046\***

Page 2

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>		0.00		8/2/6/19		(F7)			
QC	Memo								
Quality Control									
130		0.00							
<b>*130*</b>		0.00				Fx			9/12/6/20
Small Fab	Memo								
Small Fab	1- C'sink holes as per dwg								
140	QC5- Inspect part completeness to step on W/O	0.00							
<b>*140*</b>		0.00		8/2/6/20		(F7)			
QC	Memo								
Quality Control									

73

W/O:		WORK ORDER CHANGES					
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Page 3

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Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Identify as per dwg & Stock Location: 098

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

*12/6/20 (79)*

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

*12/6/20*  
*MLJ 12/06/20*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

May-31-12 3:40:43 PM

Page 1

Work Order ID: 85046

\*85046\*

Parent Item: D4110-3

\*D4110-3\*

Parent Item Name: Doubler, Sill

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	271.4720	0.1	0.421053	⑦	11	

\*M304S16GA\*

\*\*

1812-0-09

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

271.472

121626

143.972

121889

127.5

121889

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries





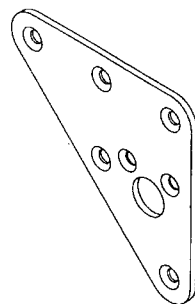
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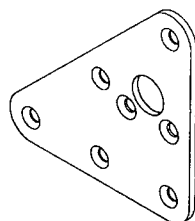
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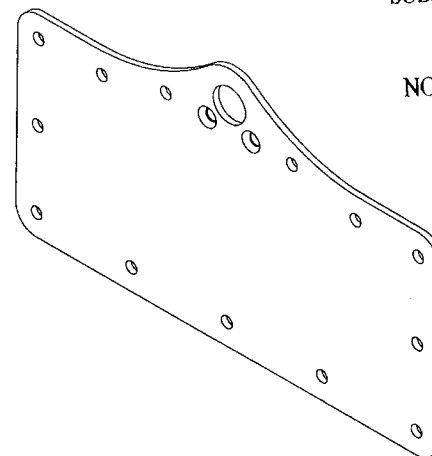
**NOTE:** Date & initial all entries



D4110-1 DOUBLER, LH DOOR



D4110-2 DOUBLER, RH DOOR



D4110-3 DOUBLER, SILL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85046 MLS  
12/06/01

**RELEASED**  
2010-09-23  
AND

A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4110	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER	NTS
DATE	10.07.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

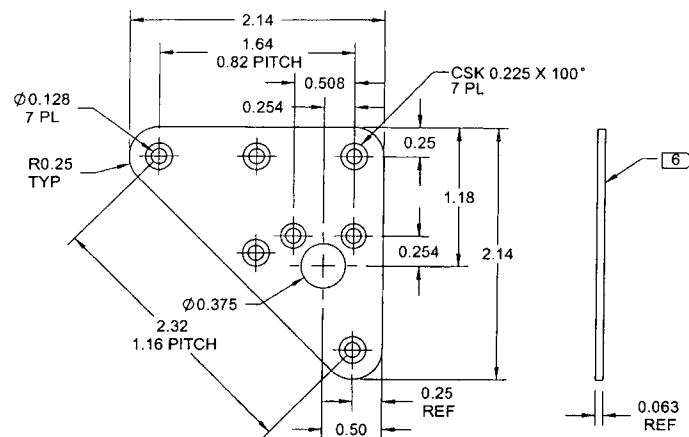
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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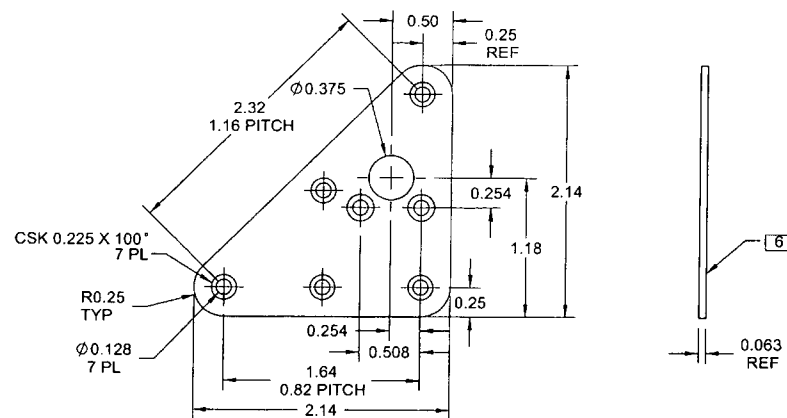
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**NOTE:** Date & initial all entries



**D4110-1 DOUBLER, LH DOOR**



**D4110-2 DOUBLER, RH DOOR**

**NOTES:**

- 1) MATERIAL -1 & -2: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4110-X & B/N PER QSI 044 6.1
- 7) WEIGHT -1 & -2: 0.05 lbs

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MFG. APPR.	JPH	<b>D4110</b>	SHEET 2 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	<b>DOUBLER</b>	NTS
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2010-09-23

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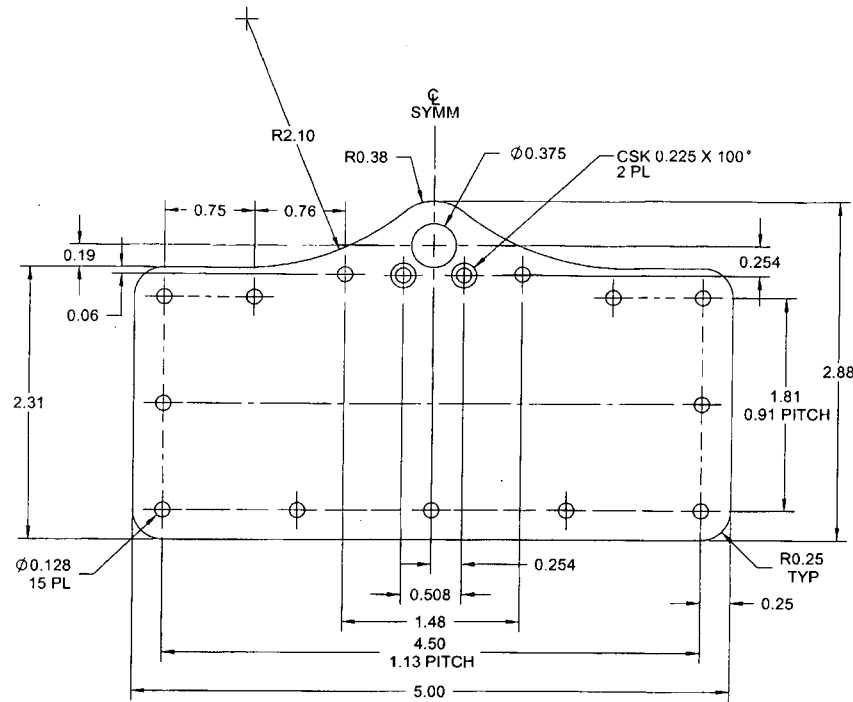
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25046



**D4110-3 DOUBLER, SILL**

**RELEASED**  
2010-09-23

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4110-3 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.21 lbs

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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CHECKED	JPH	DRAWING NO. <b>D4110</b>	REV. A
MFG. APPR.	JPH	TITLE	SHEET 3 OF 3
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